

Work Order ID 121198

Tuesday, June 17, 2014 1:18:50 PM

121198

Page 1

Item ID: D3140-87 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 6/20/2014 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 6/20/2014 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: CL Date: 14/6/17 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3140 | Rev F | | | | | | | | |

100 0.00
100 SHEAR
Shear Memo 0.00 7 FF 14-06-24
Shear Cut as per dwg D3140

110 0.00
110 Small Fab
Small Fab Memo 0.00 7 FF 14-06-24
Small Fab 1-Scuff surfaces with 80grit sandpaper per QSI 0062-Deburr. No sharp edges

120 0.00
120 QC5- Inspect part completeness to step on W/O
QC Memo 0.00 7
Quality Control

DAS
27
9-89
14/6/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Page 2

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|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 140 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | Identify as per dwg & Stock Location: <u>8T174</u> | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

DAS
27
9-89

4/6/27

7 MB14626

7

7x 14-7-1

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
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FAULT CATEGORY

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Page 3

Item ID: D3140-87

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 6/20/2014 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/20/2014 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS 14-07-02

ME 14-7-01

2024 T35 .032 M 127660 7x 7x43"

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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| | | | | | | | | | | | | | | | | | | |
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|--|--|---|--|



| | | | |
|------------------|----------------|--|------------------------|
| DESIGN # | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED Jsh | APPROVED # | DRAWING NO. D3140 | REV. F SHEET 1 OF 7 |
| DATE 06.10.06 | | TITLE DOOR | SCALE NTS |
| A | 02.04.18 | NEW ISSUE | |
| B | 03.01.23 | REMOVE -65/-81/-83; ADD -301/-303 | |
| C | 04.11.08 | CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106° | |
| D | 05.11.23 | ADD -103/-104/-105/-106; REMOVE -67 | |
| E | 06.06.09 | 1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10 | |
| F | 06.10.06 | ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE | |

RELEASED

06.11.13 #

CLY106/17

W10: 12/198

| QTY -05 | QTY -06 | QTY -07 | QTY -08 | QTY -09 | QTY -10 | PART NUMBER | DESCRIPTION |
|------------|------------|------------|------------|------------|------------|--------------|------------------|
| X | | | | | | D3140-05 | DOOR |
| | X | | | | | D3140-06 | DOOR |
| | | X | | | | D3140-07 | DOOR |
| | | | X | | | D3140-08 | DOOR |
| | | 1 | | X | | D3140-09 | DOUBLER ASSEMBLY |
| | | | 1 | | X | D3140-10 | DOUBLER ASSEMBLY |
| 3 | 3 | | | | | D3140-57 | PAD |
| 1 | 1 | | | | | D3140-59 | PAD |
| 2 | 2 | | | | | D3140-61 | PAD |
| 2 | 2 | | | | | D3140-63 | PAD |
| | | 1 | 1 | | | D3140-69 | PAD |
| | | 1 | 1 | | | D3140-71 | PAD |
| | | 1 | 1 | | | D3140-73 | PAD |
| | | 1 | 1 | | | D3140-75 | PAD |
| | | 1 | 1 | | | D3140-77 | PAD |
| | | 1 | 1 | | | D3140-79 | PAD |
| | | | | 1 | 1 | D3140-85 | ANGLE |
| 1 | 1 | | | | | D3140-87 | DOUBLER |
| | | | | 1 | 1 | D3140-89 | DOUBLER |
| | | 1 | | | | D3140-91 | DOUBLER |
| | | | 1 | | | D3140-92 | DOUBLER |
| 3 | 3 | | | | | D3140-95 | DOUBLER |
| 1 | | | | | | D3140-97 | DOUBLER |
| | 1 | | | | | D3140-98 | DOUBLER |
| | | 1 | 1 | | | D3140-99 | DOUBLER |
| | | 2 | 2 | | | D3140-101 | DOUBLER |
| | | 1 | | | | D3140-103 | DOUBLER |
| | | | 1 | | | D3140-104 | DOUBLER |
| | | 1 | | | | D3140-105 | DOUBLER |
| | | | 1 | | | D3140-106 | DOUBLER |
| 1 | 1 | | | | | D3140-241 | DOUBLER |
| 1 | | 1 | | | | D3140-301 | DOUBLER |
| | 1 | | 1 | | | D3140-303 | DOUBLER |
| | | | | 5 | 5 | MS20426AD3-4 | RIVET |



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| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>th</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>th</i> | APPROVED <i>th</i> | DRAWING NO. D3140 | REV. F SHEET 2 OF 7 |
| DATE 06.10.06 | | TITLE DOOR | SCALE NTS |

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

| PART | TOOL |
|-----------|---------------|
| D3140-05 | B30-23000-01T |
| D3140-06 | B30-23000-02T |
| D3140-07 | B30-23000-03T |
| D3140-08 | B30-23000-04T |
| D3140-57 | B30-23000-57T |
| D3140-61 | B30-23000-61T |
| D3140-63 | B30-23000-63T |
| D3140-69 | B30-23000-69T |
| D3140-71 | B30-23000-71T |
| D3140-73 | B30-23000-73T |
| D3140-75 | B30-23000-75T |
| D3140-77 | B30-23000-77T |
| D3140-79 | B30-23000-79T |
| D3140-89 | D3140-89T1 |
| D3140-301 | D3140-301T1 |
| D3140-303 | D3140-303T1 |

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

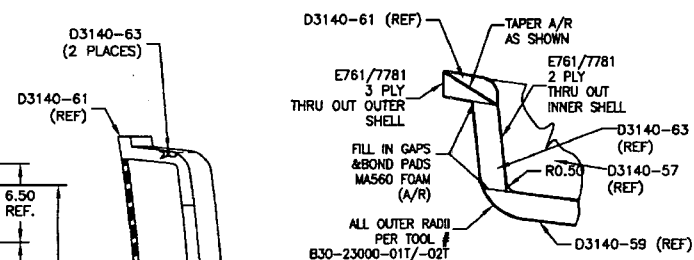
14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1

F

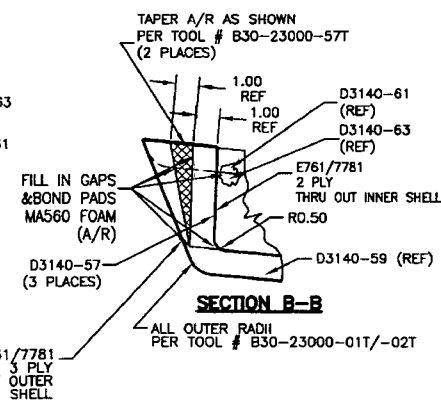
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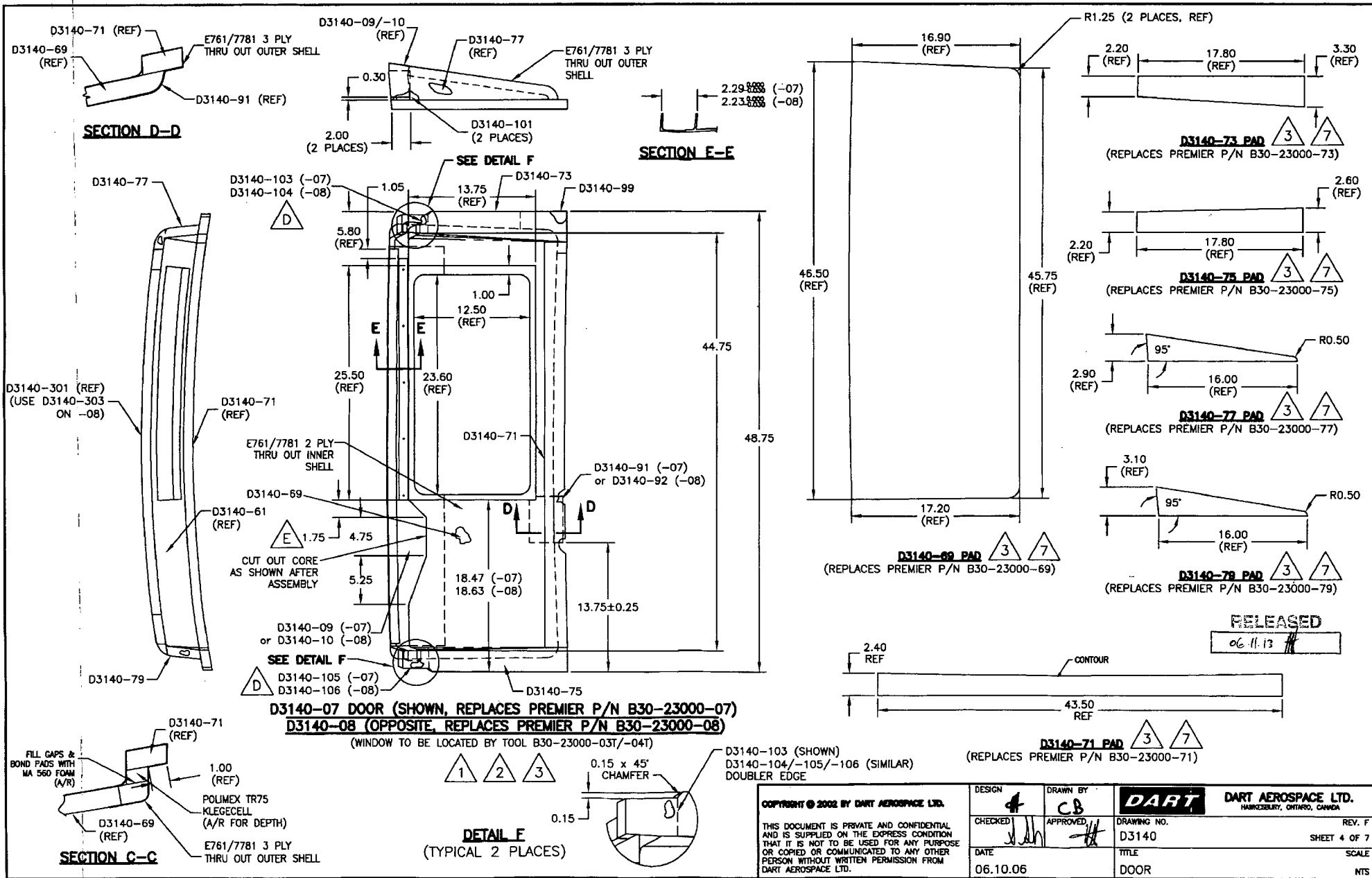
06.11.13

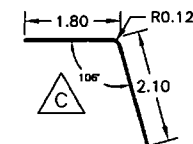
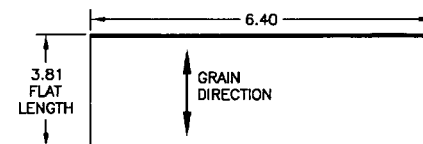
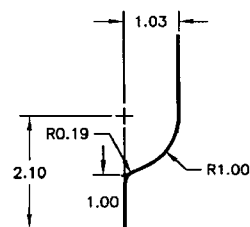
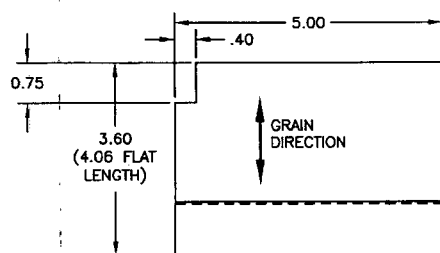
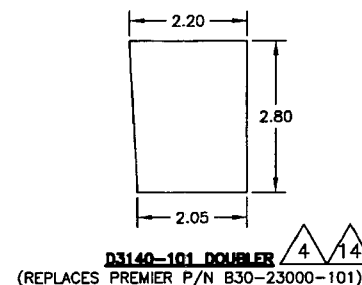
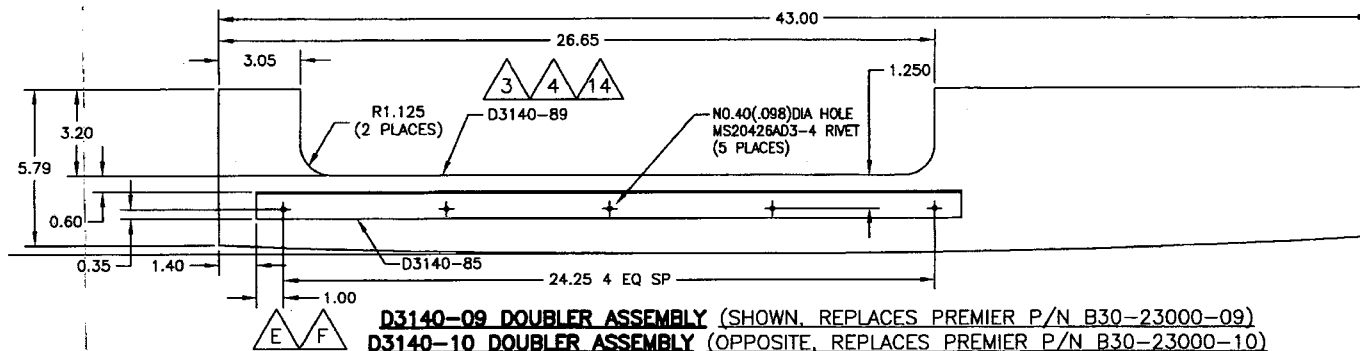


SECTION B-E

1 2 3

SCALE





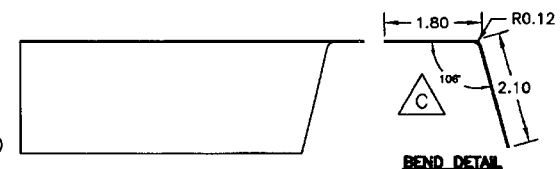
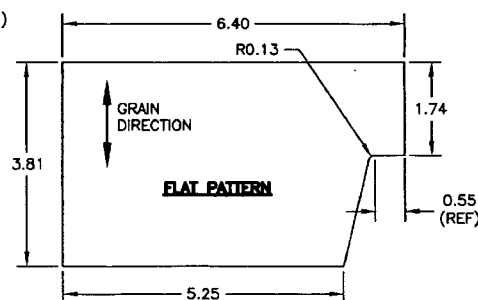
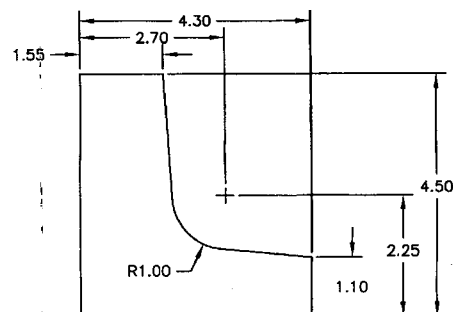
D3140-91F FLAT PATTERN
(USE TO MAKE D3140-91/-92 DOUBLERS)

D3140-92 DOUBLER
(SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-91)

D3140-95 DOUBLER
(REPLACES PREMIER P/N B30-23000-95)

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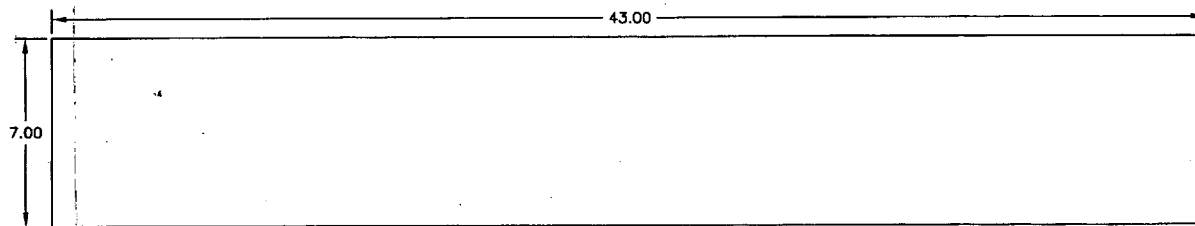
D3140-97F FLAT PATTERN
(USE TO MAKE D3140-97/-98 DOUBLERS)

D3140-97 DOUBLER
(SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

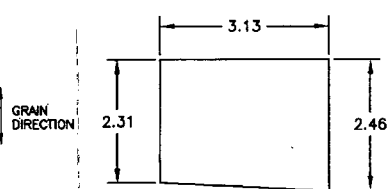
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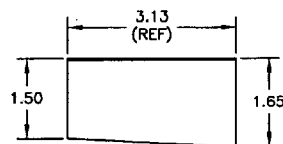
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|---------|----------|----------|------|-------------|--|
| DESIGN | 4 | DRAWN BY | CB | DART | DART AEROSPACE LTD. WARRINGTON, ONTARIO, CANADA |
| CHECKED | JH | APPROVED | JH | DRAWING NO. | D3140 |
| DATE | 06.10.06 | TITLE | DOOR | REV. F | SHEET 5 OF 7 |
| | | | | SCALE | MTS |



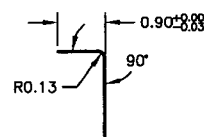
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



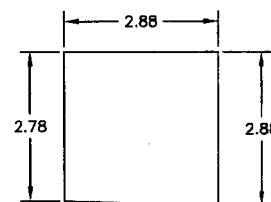
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(USED TO MAKE D3140-105/-106 BRACKETS)



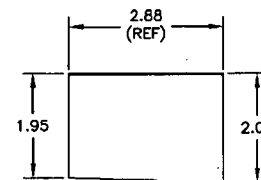
D3140-105 DOUBLER
D3140-106 OPPOSITE



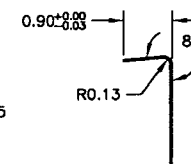
GRAIN DIRECTION



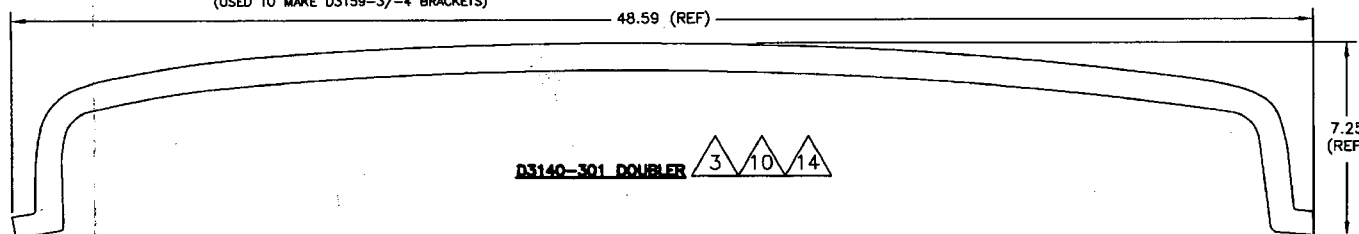
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



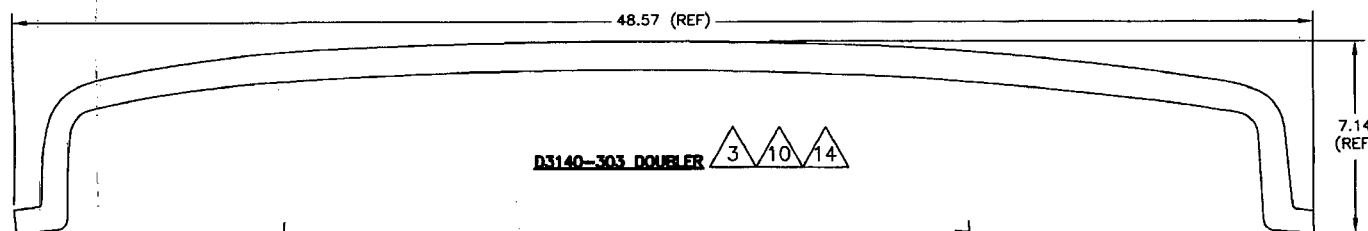
D3140-104 DOUBLER
D3140-103 OPPOSITE



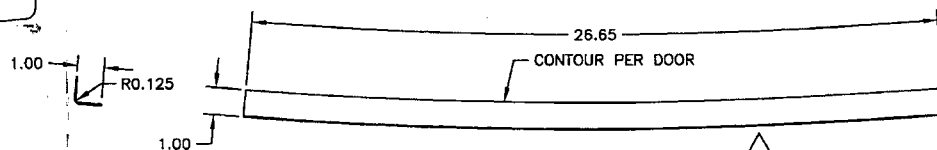
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



D3140-303 DOUBLER



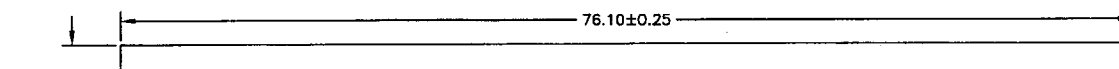
D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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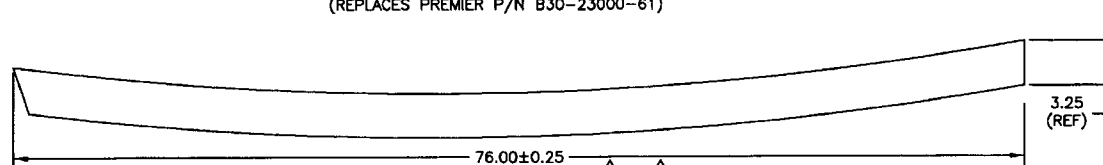
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|--------------------|-----------------------|----------------------|---|
| DESIGN 4 | DRAWN BY CB | DART | DART AEROSPACE LTD. MIDLAND, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D3140 | REV. F SHEET 6 OF 7 |
| DATE 06.10.06 | TITLE DOOR | SCALE | NTS |

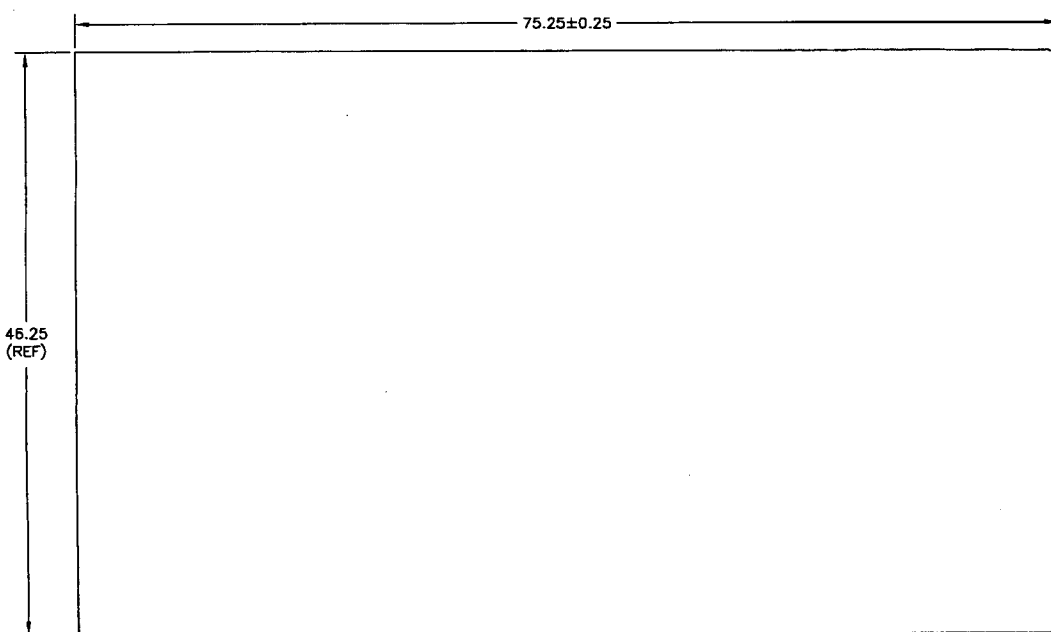


2.20
(REF)

D3140-61 PAD $\triangle 3 \triangle 7$
(REPLACES PREMIER P/N B30-23000-61)

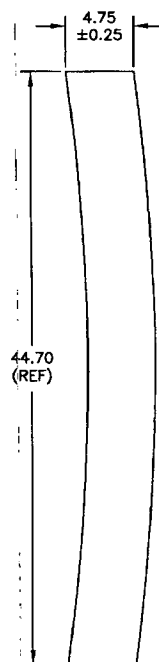


D3140-63 PAD $\triangle 3 \triangle 7$
(REPLACES PREMIER P/N B30-23000-63)



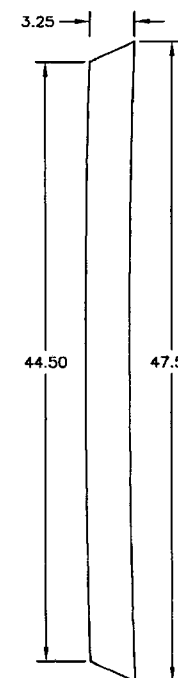
D3140-59 PAD $\triangle 7$
(REPLACES PREMIER P/N B30-23000-59)

R1.00
(2 PLACES, REF)



D3140-57 PAD
(REPLACES PREMIER
P/N B30-23000-57)

$\triangle 3 \triangle 7$



D3140-241 DOUBLER $\triangle 5 \triangle 14$
(REPLACES PREMIER P/N B30-23000-241)

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DESIGN

#

DRAWN BY

CB

CHECKED

APPROVED

DATE

06.10.06

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3140

TITLE

DOOR

REV. F

SHEET 7 OF 7

SCALE

NTS

DART AEROSPACE LTD

Work Order: 121198

Description: Doubler

Rev:

Part Number: D 3140-87

INSPECTION SHEET

[illegible]

Measured by:

FF

Date 14-06-25

Checked By: DAS
30
9-89

Date _____

14/06/25

QC inspector: DAS
27
9/89

Date _____

14/0/25 989

Engineering Approval (if not)

Date _____